

Date: Thursday, 3/20/2008 9:54:08 AM
User: Kim Johnston

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	02.750 SUPPORT
Job Number :	38123		
Estimate Number :	10829		
P.O. Number :		Part Number :	D28931
This Issue :	3/20/2008 S.O. No. :	Drawing Number :	D2893 REV B
Prsht Rev. :	NC	Project Number :	N/A
First Issue :	1 / Type : MACHINED PARTS	Drawing Revision :	B
Previous Run :	37962	Material :	
Written By :		Due Date :	4/3/2008
Checked & Approved By :	<u>1808 03 20</u>	Qty:	9
Comment :	Est: C 02.11.26 Reformat; Added P/O KJ	Um:	20
	est D 06.04.19 removed alodine EC	Each	
	Est Rev:E Added priming as per Rev B 07-04-30 JLM		
	est F 08.03.19 Re-format EC verified by:		
	DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

Previous Run

DSK078

D2893-1 TURNING DETAIL

Written By



Comment:

Qty.: 0.5000 Each(s)/Unit Total: 10.0000 Each(s)

D2893-1 TURNING DETAIL

Batch: 38131

2.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS 1

Machine as per Folio FA081

Tumble & Deburr

J.L 08/04/21

Previous Run

QC2

INSPECT PARTS AS THEY COME OFF MACHINE

Written By



Comment:

INSPECT ALL DIM TO DIM SHEET

J.L 08/04/21

Previous Run

QC8

SECOND CHECK

Written By



Comment: SECOND CHECK

S.F 08/04/21

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Mask Inside Bore for Priming

M 107550

BR 08-04-22

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/20/2008 9:54:08 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 02.750 SUPPORT

Job Number: 38123

Part Number: D28931

Job Number:



Seq. #

Machine Or Operation:

Description :

6.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

Prime inside surface as per Dwg D2893 and QSI 005 4.3.

ml 08 04 24

18

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

RT 08-04-25

18

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: LG

ml 08 04 25

18

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/04/28

Job Completion



mf

08-04-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 38123
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.128							
L									
HAAS Section									
AA	2.985	3.005		3.003	2.994	2.992	2.991		
AB	0.440	0.460		.440	.440	.440	.440		
AC	0.125	0.160		.143	.145	.145	.146		
AD	0.040	0.060		.042	.042	.042	.041		
AE	0.188	0.193		.189	.189	.189	.189		
AF	0.125	0.160		.141	.143	.142	.144		
AG	0.140	0.160		.152	.152	.152	.150		
AH	1.360	1.400		1.380	1.368	1.371	1.371		
AI	0.040	0.060		.047	.048	.051	.052		
AJ	1.190	1.230		1.215	1.209	1.216	1.216		
AK	0.010	0.020		.011	.011	.011	.011		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.538	2.538	2.538	2.538		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by: J.L
Date: 08/04/20

Audited by: S.F
Date: 08/04/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38123
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		2.992	2.993	2.992	2.992		
AB	0.440	0.460		.440	.440	.440	.440		
AC	0.125	0.160		.148	.145	.146	.146		
AD	0.040	0.060		.042	.043	.042	.042		
AE	0.188	0.193		.189	.189	.189	.189		
AF	0.125	0.160		.144	.144	.145	.143		
AG	0.140	0.160		.150	.149	.149	.149		
AH	1.360	1.400		1.368	1.368	1.371	1.373		
AI	0.040	0.060		.049	.051	.047	.049		
AJ	1.190	1.230		1.211	1.214	1.212	1.216		
AK	0.010	0.020		.011	.011	.011	.011		
AL	0.053	0.073		.063	.063	.063	.063		
AM	0.240	0.260		.250	.250	.250	.250		
AN	2.518	2.538		2.538	2.538	2.538	2.538		
AO	84.39	90.39		87.39	87.39	87.39	87.39		
AP	0.261	0.266		.261	.261	.261	.261		
AQ	0.053	0.073		.063	.063	.063	.063		
AR									
AS									
Accept/Reject									

Measured by:	J.L.
Date:	08/04/21

Audited by:	B.F.
Date:	08/04/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM	

DART AEROSPACE LTD	Work Order: 38123
Description: Ø2.750 Support	Part Number: D2893-1
Inspection Dwg: D2893 Rev. B	Page 1 of 1

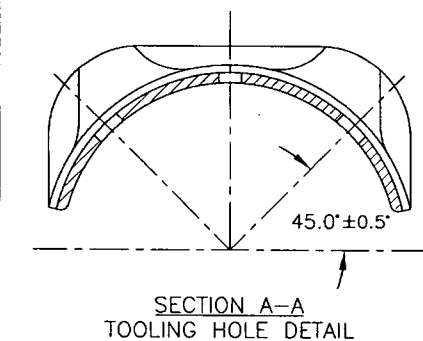
Inspect dimensions highlighted on inspection sheet drawing D2893 Rev B / DSK078 Rev A and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
Lathe Section									
A	2.707	2.712							
B	4.946	4.966							
C	3.064	3.084							
D	0.718	0.738							
E	0.090	0.110							
F	2.934	2.954							
G	2.166	2.186							
H	3.890	3.910							
I	0.914	0.934							
J	0.022	0.042							
K	0.109	0.129							
L									
HAAS Section									
AA	2.985	3.005		2.991					
AB	0.440	0.460		.440					
AC	0.125	0.160		.145					
AD	0.040	0.060		.042					
AE	0.188	0.193		.189					
AF	0.125	0.160		.144					
AG	0.140	0.160		.149					
AH	1.360	1.400		1.367					
AI	0.040	0.060		.052					
AJ	1.190	1.230		1.215					
AK	0.010	0.020		.011					
AL	0.053	0.073		.063					
AM	0.240	0.260		.250					
AN	2.518	2.538		2.538					
AO	84.39	90.39		87.37					
AP	0.261	0.266		.261					
AQ	0.053	0.073		.063					
AR									
AS									
Accept/Reject									

Measured by: J.L.
Date: 08/04/21

Audited by: [Signature]
Date: 08/04/21

Rev	Date	Change	Revised by	Approved
A	02.12.13	New Issue	KJ/RF	
B	07.05.08	Dimension AP revised	KJ/JLM [Signature]	[Signature]



1) MATERIAL: 17-4 PH STAINLESS STEEL
HEAT TREAT TO H900 CONDITION
(900°F FOR 1 HR, AIR COOL)
MIN UTS = 170 KSI (38 HRC)

PRIME ONLY

7 B

2) IDENTIFY WITH DART LOGO AND PART NUMBER IN
THIS AREA WITH 0.125 HIGH LETTERING 0.010-0.020 DEEP

3) BREAK ALL UNMARKED SHARP EDGES 0.010 TO 0.020

4) PART IS SYMMETRIC ABOUT CENTERLINE

5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED






6) ALL DIMENSIONS ARE IN INCHES

7) FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
PRIME INSIDE SURFACE AS SHOWN PER DART QSI 005 4.2

1.210±0.02

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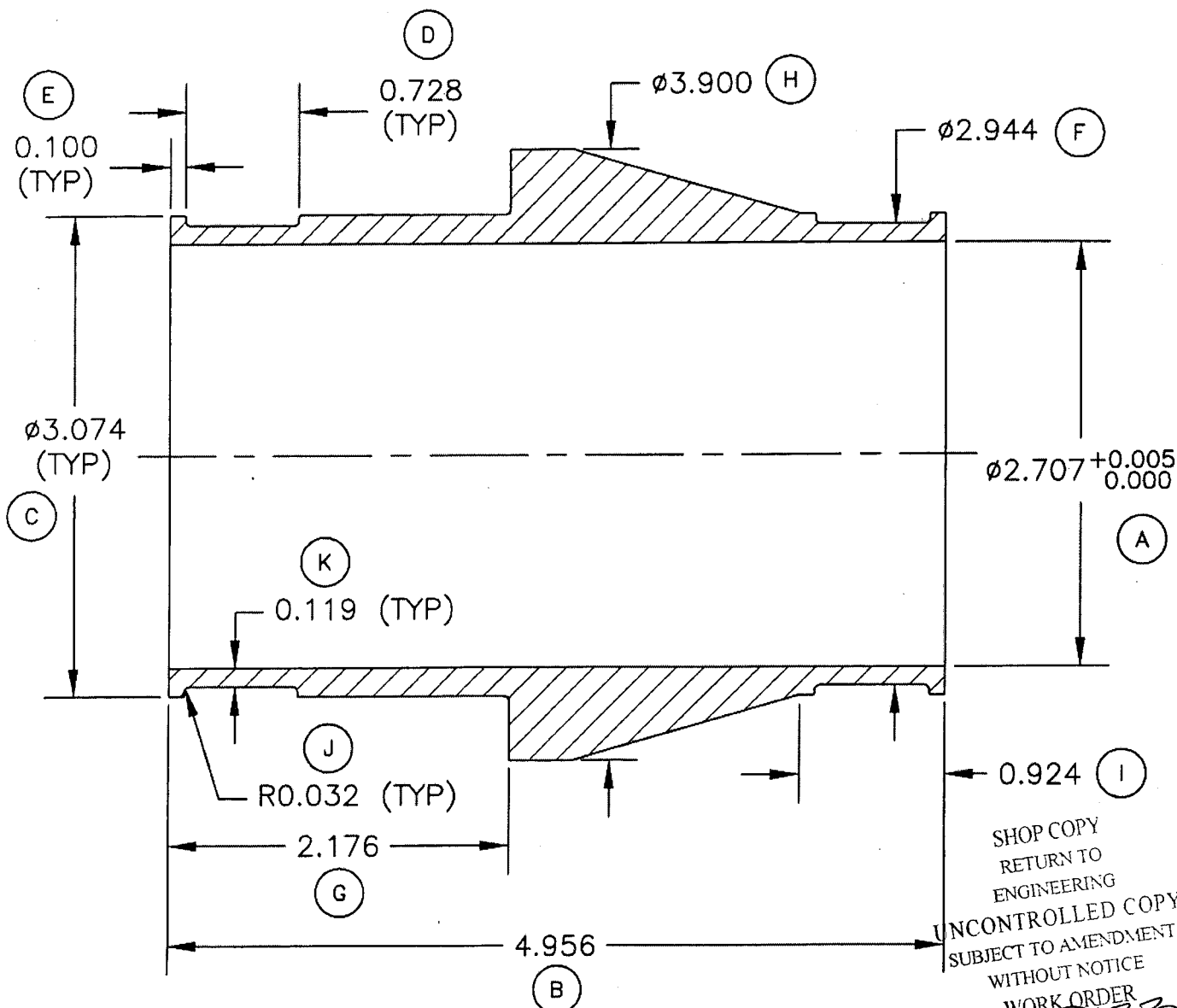
WORK ORDER
NO. 3823
5

B	07.03.16	UPDATE DIMS AS MFG., PRIME INSIDE	
A	01.01.10	NEW ISSUE	
DESIGN	 DRAWN BY 		DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED	 APPROVED 	DRAWING NO. D2893	REV. B SHEET 1 OF 1
DATE	07.03.16	TITLE Ø2.750 SUPPORT	



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSK 078	REV. A SHEET 1 OF 1
DATE 03.05.20		TITLE TURNING DETAIL FOR D2893-1	SCALE 1:1
A	03.05.20	NEW ISSUE	

RELEASED
03.07.01



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NO. 38123

D2893-1 TURNING DETAIL

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